

Date: Thursday, 5/4/2006 7:12:00 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 8" MIRROR
Job Number	: 26938		
Estimate Number	: 10103		
P.O. Number	: N/A	Part Number	: D2011103
This Issue	: 5/4/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2011 REV. F
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: F
	Type : SMALL /MED FAB	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/11/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	50 Um: Each
Comment	: Est: J 04.09.15 Added Steps 5-7 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

Velvac Mirror P/N: 708441

Possible supplier: UAP/NAPA

Material release note required

1246 C206105/15 (50)
 116# - Can't find P/N# need using item
 U 06.05.04
 rec'd wrong item

2.0

708441

MIRROR 8"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
 Mirror 8"

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

AL 06/05/08 (50)

4.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
 Locknut

Pick:

Qty Part Number Description Batch

1 D3015-3 Lock nut

20 B 25/49

22 B 25/99

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-05-24	3-D	Add QCG permanent change made QCG done by 06-05-24						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/05/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/4/2006 7:12:00 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 8" MIRROR

Job Number: 26938

Part Number: D2011103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD516 Washer

M19185

M.F. 06-05-24

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Black Sikaflex adhesive per hole.

Qty Part Number Description Batch

A/R Sikaflex-291

Expiry date

M10090

06-11-24

Test assembly to 50lbs pull test after 24 hours

Start: Time:

Finish: Time:

N/A

FF. 06.05.24 50

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST200

P415/26 (50)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

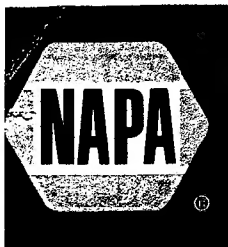
Inspection Level 21

2006/05/29

Job Completion



4 06-05-26



HAWKESBURY AUTO PARTS INC 5580GST#:
14 MAIN STREET WEST
HAWKESBURY, ONT. K6A 2J2
TEL: 632-8575 FAX: 632-1539

861597896RT0001
EXC#: SU 6259 EXP: 03/12/31
DANGEROUS GOODS PERMIT
EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

DOCT #	SOLD TO	DATE	TIME	STORE #	EMP #	INVOICE NO.
01601	DART AEROSPACE LTD	5/16/06	15:53	060004074	31	119115
SR #	1270 ABERDEEN STREET	PURCHASE ORDER #				ATTENTION
6	HAWKESBURY, ONTARIO	1246				
AD	K6A 1K7	TAX EXEMPTION: 6122-5207				
14		TERMS: NET 30 DAYS				CHARGE SALE
		DELIVERY:				

PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
708441		GRO CONVEX MIRROR	50.00		23.950	1197.50 T15C

REFUNDED BY [Signature]
VERIFIED BY [Signature]

Subtotal 1197.50
Tax 7% GST ONLY 83.83
Tax 0% 0.00

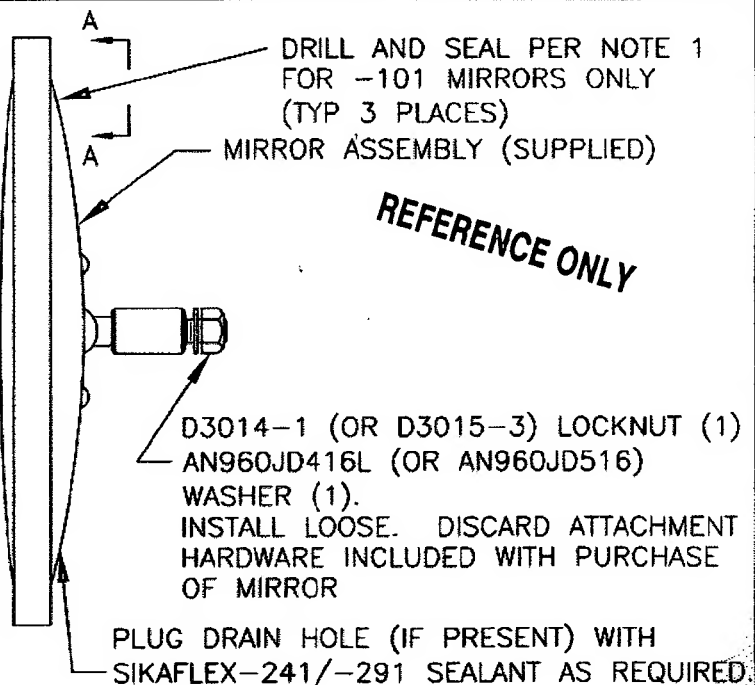
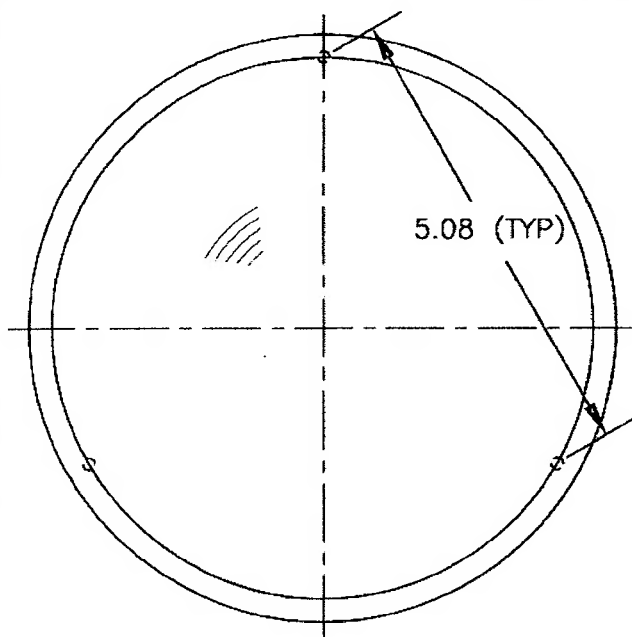
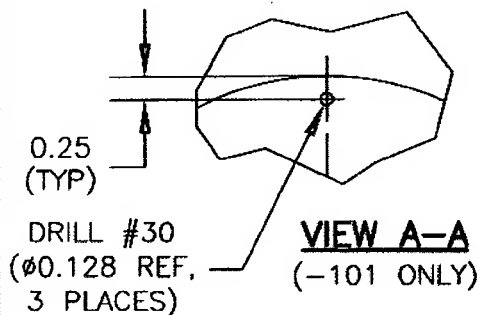
SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL ----> CHARGE SALE 1281.33



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10	TITLE MIRROR ASSEMBLY		SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



REFERENCE ONLY

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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RELEASED
04.09.10